

**Work Order ID 68401**

Tuesday, April 12, 2011 3:37:03 PM

**PRELIMINARY ISSUE**

Page 1

Item ID: D4367-1

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Bar

Start Date: 4/12/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 1.00

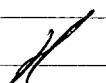


Customer:



Reference:

Approvals:

Process Plan: 

Date: 11/04/12

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D4367

PA1

100

0.00



Cold Saw

Memo

0.00

Hyd Mech

Cut blanks at 51.250"

49.75

11/04/27

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Mill as per folio EB042 &amp; dwg D4367,

FOLIO REV: \_\_\_\_\_

DWG REV: \_\_\_\_\_

2-Deburr as required

Manual Mill

11/04/28

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

\_\_\_\_\_

Tuesday, April 12, 2011 3:37:03 PM

**Accept**

**Setup Start**

**Stop**

[illegible]**Cust Item ID:**

\_\_\_\_\_

**Customer:**

**Reference:**

Run Start

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Stop**

**Insp.  
Stamp**

0.00

**RESEARCH DESIGN AND METHODS**

QC

## Memo

0.00

## Quality Control

130

0.00

\_\_\_\_\_

QC

## Memo

0.00

## Quality Control

140

0.00

[illegible]

### Small Fab

## Memo

0.00

## Small Fab

.. Grind off chamfer on fwd end of bar as per dwg

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Work Order ID 68401



Page 3

Tuesday, April 12, 2011 3:37:03 PM

Item ID: D4367-1	Accept		Setup	Start	
Revision ID: PRELIM				Stop	
Item Name: Bar					
Start Date: 4/12/2011	Start Qty: 1.00		Cust Item ID:		
Required Date: 4/15/2011	Req'd Qty: 1.00		Customer:		
Reference:					

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00							
160  Packaging Packaging	Identify as per dwg & Stock Location: <u>W/A</u> 025  Memo	0.00 0.00							
170  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							

POSITIVE RECALL

EFFECTIVE 11/04/13 AUTH U

RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

LD 3302  
11

ME  
11-05-03

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Page 1

Tuesday, April 12, 2011 3:37:09 PM

Work Order ID: 68401



Parent Item: D4367-1

Parent Item Name: Bar

Start Date: 4/12/2011

Required Date: 4/15/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 11.04.12 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500		Purchased	No			100	f	269.5000	4.27	4.494737			
304 BAR .250 x .500													

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT006	78	
116148	78	
MAT050	191.5	
117176	191.5	

4.3 11/04/27

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**NOTE:** Date & initial all entries



8 7 6 5 4 3 2 1

D

D

C

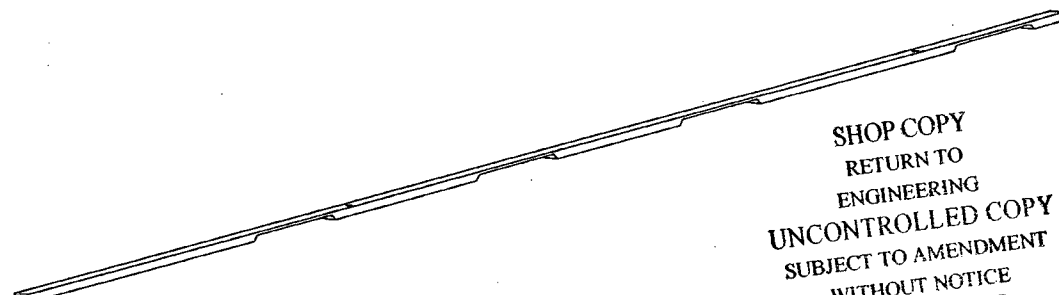
C

B

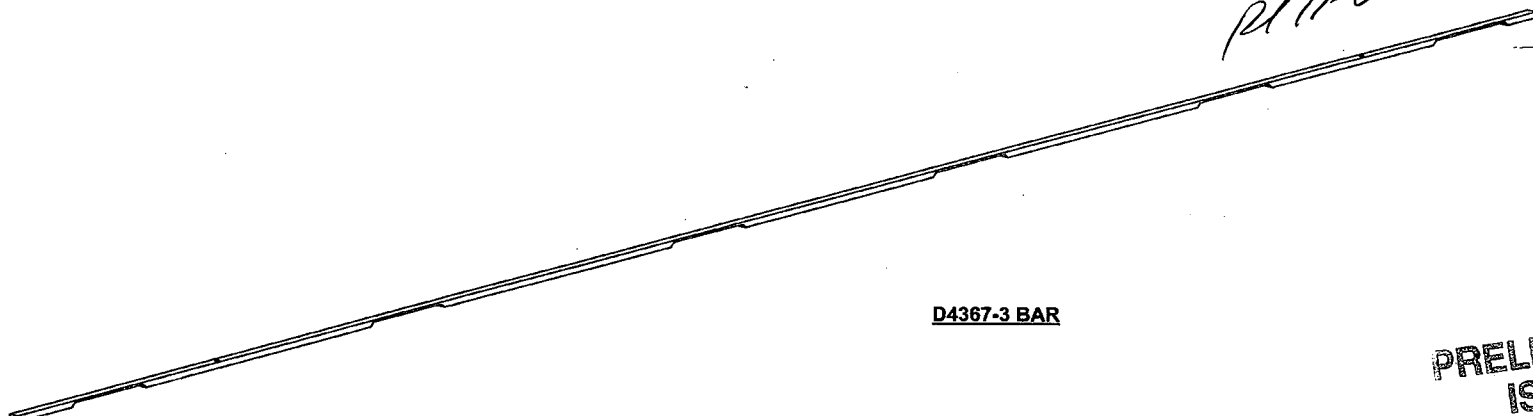
B

A

A



**D4367-1 BAR**



**D4367-3 BAR**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 68401

*PL 11-04-12*

**PRELIMINARY  
ISSUE**

PA1	NEW ISSUE	SC	11.03.24
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
DRAWN	SC		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. PA1
MFG. APPR.	<i>[Signature]</i>	D4367	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BAR	NTS
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8 7 6 5 4 3 2 1

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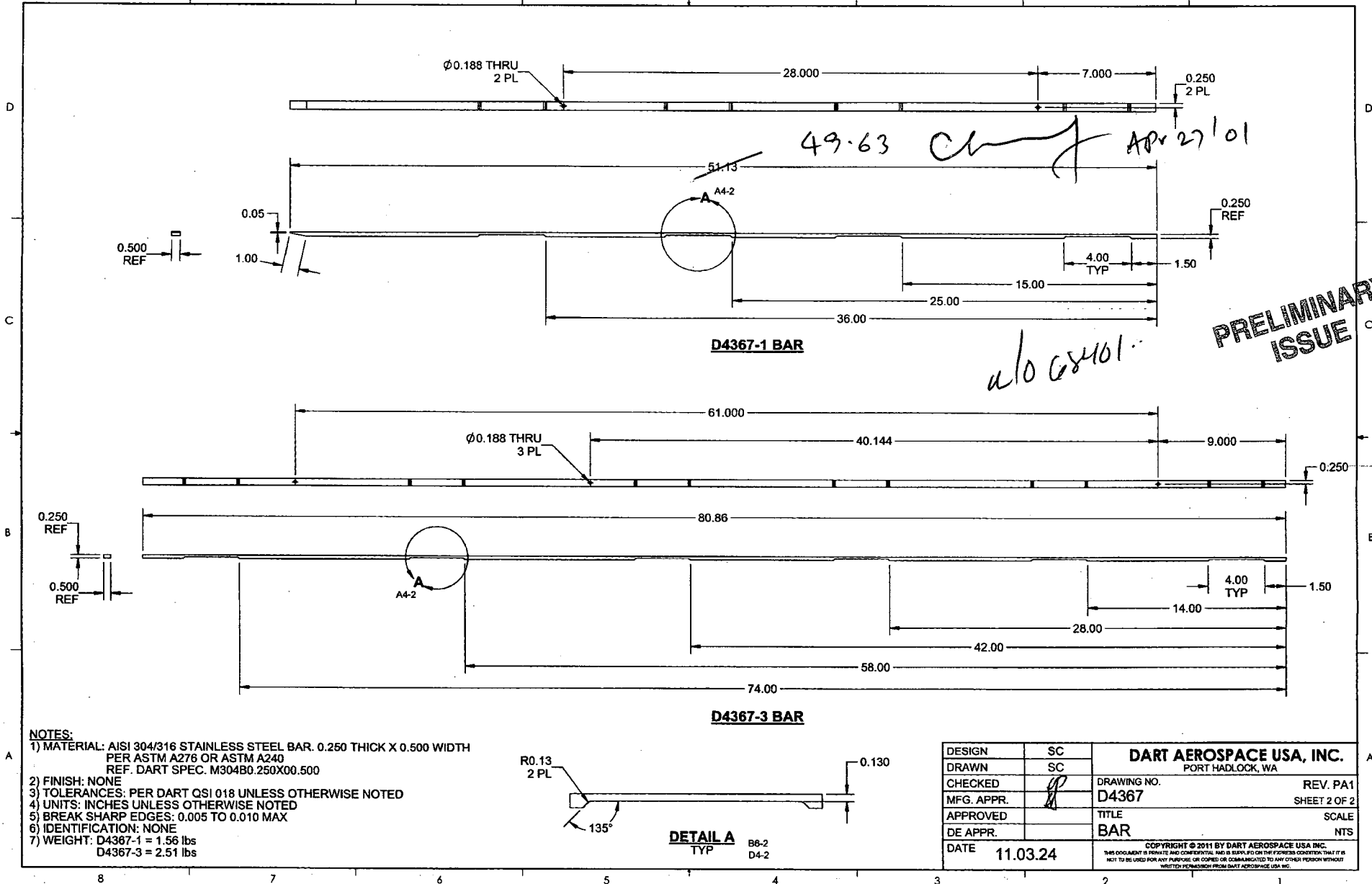
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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8 7 6 5 4 3 2 1



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DRAWN	SC		
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D4367	SHEET 2 OF 2
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DE APPR.		BAR	NTS
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